

PRELIMINARY ISSUE

Work-Order ID 61925-1

Thursday, September 09, 2010 12:54:33 PM

Item ID: D4180-3

Accept



Setup



Revision ID: PRELIM

Start



Item Name: Gusset

Stop



Start Date: 9/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-9-09

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4180	PA1

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

10-9-13

I-Cut as per Dwg
Dwg Rev: PM
Prog Rev: PM

2-Deburr if necessary

4

110



Memo

0.00

10-9-13

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61925

Thursday, September 09, 2010 12:54:33 PM



Page 2

Item ID: D4180-3

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00



Required Date: 9/16/2010 Req'd Qty: 2.00



Accept



Setup

Start



Stop



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

- 10/04/13

(44)

inspected to PMS

Day only

Tool ID

0.00

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61925

Thursday, September 09, 2010 12:54:33 PM



Page 3

Item ID: D4180-3

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Accept



Setup Start



Required Date: 9/16/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

24 10/09/10

4 0

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 10 9-16

④ Ø

170



Packaging

Packaging

Identify as per dwg & Stock Location: CA

0.00

Ian

0.00

AT 10-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61925

Thursday, September 09, 2010 12:54:33 PM



Page 4

Item ID: D4180-3

Revision ID: PRELIM

Item Name: Gusset

Start Date: 9/9/2010 Start Qty: 2.00

Required Date: 9/16/2010 Req'd Qty: 2.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop

Sequence ID/
Work Center ID

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

10/09/29/H

POSITIVE RECALL

EFFECTIVE 10/09 AUTH H

RELEASED 10/09 DATE 10/09/29

10/09/29/H

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 09, 2010 12:54:38 PM

Page 1

Work Order ID: 61925



Parent Item: D4180-3



Parent Item Name: Gusset

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	125.2600	0.114	0.24			

6061-T6 .125 Sheet



Location	Loc Qty	Loc Code
MAT21	125.26	
113608	96	
114352	29.26	

1810-4 13

(4)

114352

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

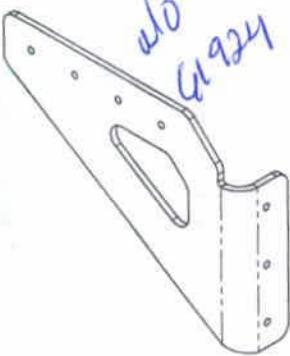
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

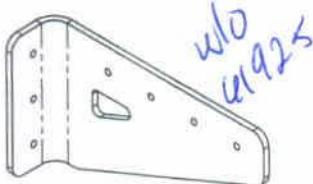
Route / Born / Arf
→ **Done**

8 2 erde

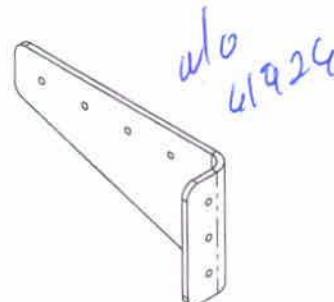
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D4180-1 GUSSET



D4180-3 GUSSET

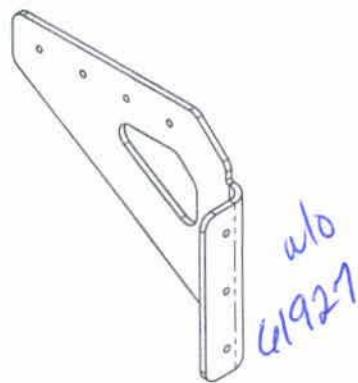


D4180-5 GUSSET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO WORK ORDER

61925

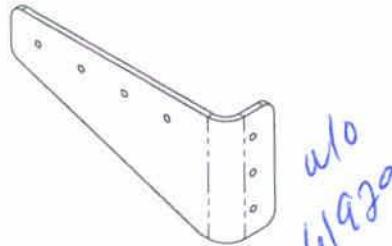
pf0-9-09



D4180-2 GUSSET



D4180-4 GUSSET

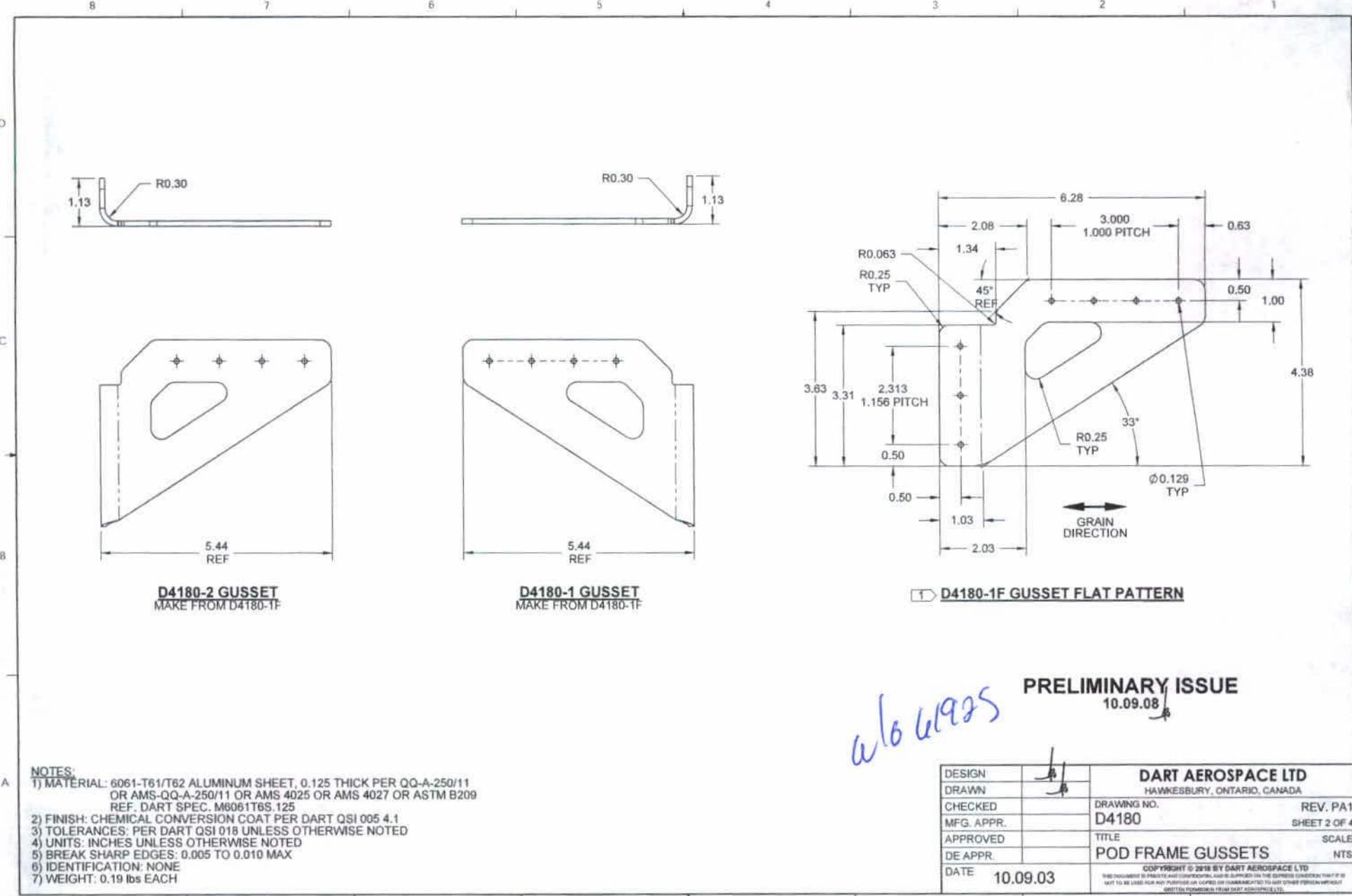


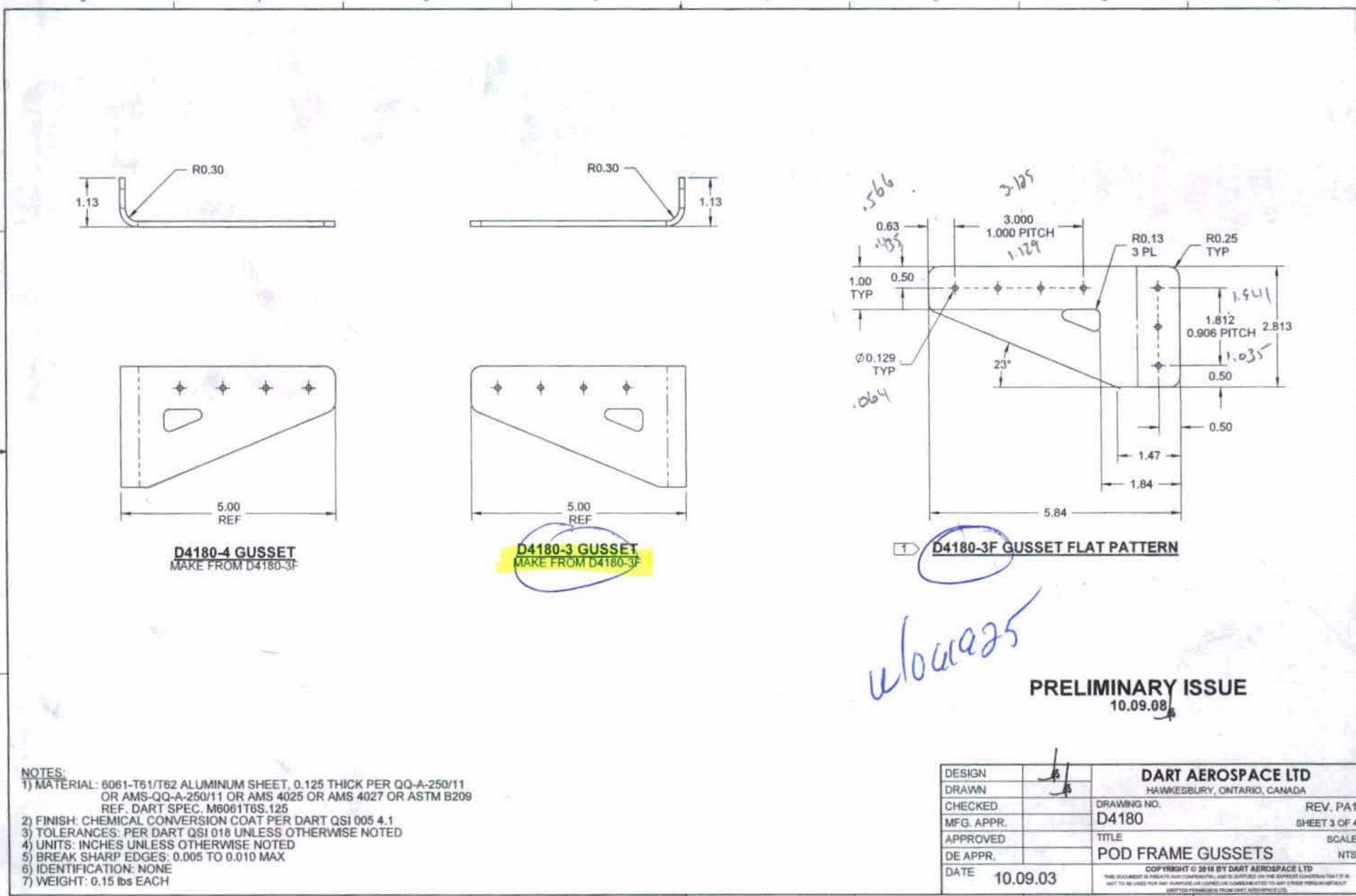
D4180-6 GUSSET

PRELIMINARY ISSUE

10.09.08

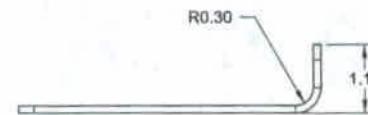
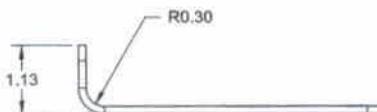
PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>5</i>	DART AEROSPACE LTD	
DRAWN	<i>5</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		POD FRAME GUSSETS	NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



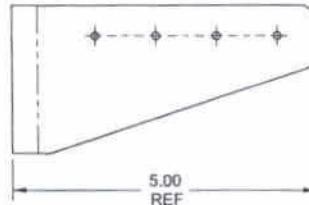


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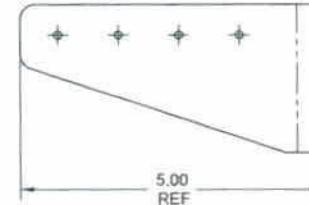
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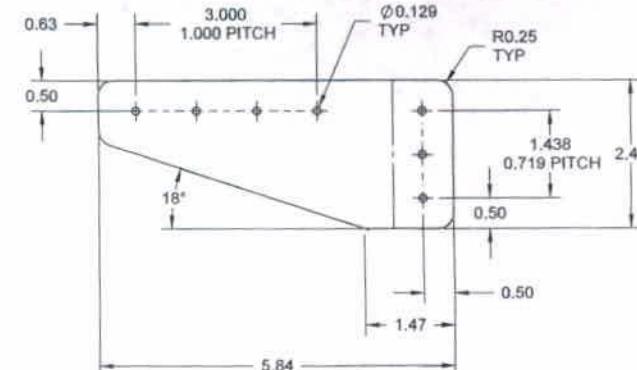
C



D4180-5 GUSSET
MAKE FROM D4180-5F



D4180-6 GUSSET
MAKE FROM D4180-5F



D4180-5F GUSSET FLAT PATTERN

B

A

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4180	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		POD FRAME GUSSETS	NTS
DATE	10.09.03	COPRIGHT © 2010 BY DART AEROSPACE LTD.	

W/0 41925

PRELIMINARY ISSUE
10.09.08

8 7 1 6 5 4 3 2 1 0

DART AEROSPACE LTD	Work Order:	61925
Description: GUSSET	Part Number:	04180-3
Inspection Dwg: 04180-3 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+.005 -.001	.130	✗		V HB07	
.50	TL -.030	.501	✗	*	V	
.63	TL -.030	.623	✗		V	
3.00	TL -.030	3.000	✗		V	
1.000	TL .010	1.000	✗		V	
2.813	TL -.010	2.817	✗		V	
1.812	TL .010	1.812	✗		V	
.906	TL -.010	.907	✗		V	
.50	TL -.030	.503	✗		V	
.50	TL -.030	.501	✗		V	
1.47	TL -.030	1.472	✗		V	
1.84	TL -.030	1.851	✗		V	
5.84	TL -.030	5.854	✗		V	
1.00	TL -.030	1.000	✗		V	
.125	TL .010	.123	✗		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-13	Date:	10-9-13	Date:	N/A
	inspected in PDI Dry only				

